



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

11505

RB6796941
Job Sheet 188408



Part No: RB6796941

Job Qty: 1 pcs

Part Name: Seals Replacement, Accessories Gear Box



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6796941 Rev. 11 IPP Rev. A 18.07.31 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/8/19	3/8/19	0.00	0.13	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/8/19	3/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/8/19	3/8/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S166555

Part: RB6796941

Job No: 188408

Serial No/Batch: S166555

Revision: 11

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/26/19

MAR 26 2019

DLS
40
188408

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
140	QC 21 - FG	1 pcs	3/8/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

21

9-ss

MAR 27 2019

RBC02A

Part Op 100 - Small Fab

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ -

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	100-Small Fab - 1	5108536
RB6796941-12	Adapter	1 Ea (1 ea)	100-Small Fab - 1	5098322
RB6796941-13	Guide	1 Ea (1 ea)	100-Small Fab - 1	5158378
RB6796941-14	Starter Seal Guide	1 pcs (1 ea)	100-Small Fab - 1	5102895
RB6796941-15	Guide	1 pcs (1 ea)	100-Small Fab - 1	5119779
RB6796941-16	Punch	1 Ea (1 ea)	100-Small Fab - 1	5144418
RB6796941-17	Punch	1 pcs (1 ea)	100-Small Fab - 1	5103413
RB6796941-18	Punch	1 pcs (1 ea)	100-Small Fab - 1	5103910
RB6796941-19	Punch	1 Ea (1 ea)	100-Small Fab - 1	5144419
RB6796941-20	Punch	1 Ea (1 ea)	100-Small Fab - 1	5153099
RB6796941-200	Tach Generator Puller	1 (1 ea)	100-Small Fab - 1	5102875
RB6796941-201	Puller Assembly/Starter Seal Removal Tool	1 Ea (1 ea)	100-Small Fab - 1	5165949
RB6796941-202	Power Take Off Seal Puller C-20	1 pcs (1 ea)	100-Small Fab - 1	5102871
RB6796941-203	Slide Hammer Assembly	1 pcs (1 ea)	100-Small Fab - 1	5076864
RB6796941-29	Bottom Foam - Y-20 Black - I.R. Specialties - Use in Case 10164	1 Ea (1 ea)	100-Small Fab - 1	5150263

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	10164	1	4	0
	RB6796941-12	1	15	0
	RB6796941-13	1	0	0
	RB6796941-14	1	16	0
	RB6796941-15	1	15	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

RB6796941-16	1	0	0
RB6796941-17	1	8	0
RB6796941-18	1	9	0
RB6796941-19	1	0	0
RB6796941-20	1	0	0
RB6796941-200	1	0	0
RB6796941-201	1	0	0
RB6796941-202	1	4	0
RB6796941-203	1	4	0
RB6796941-29	1	0	0

Part Specifications

Specifications could not be found.

Plex 1/9/19 10:46 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

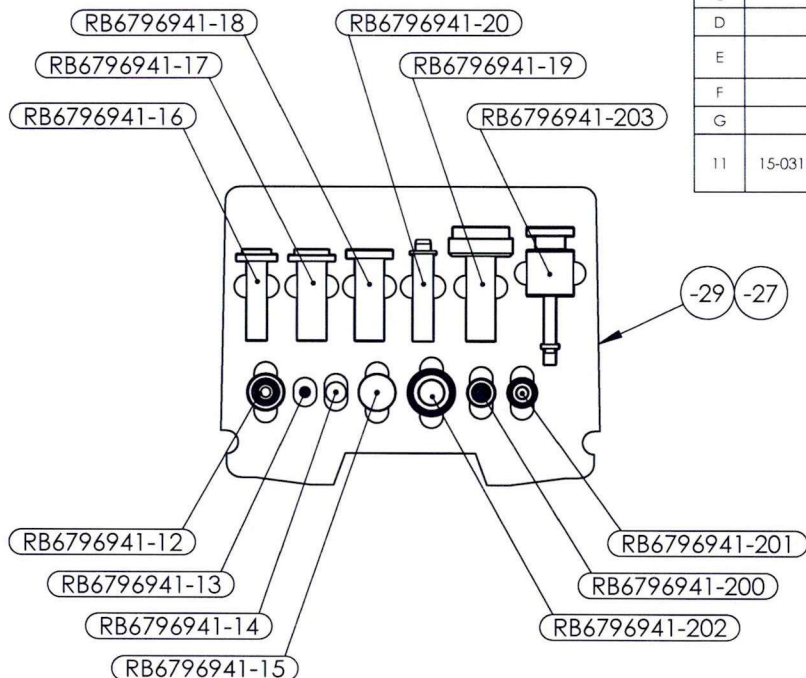
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		SEE SHEET 3 REV FROM ORIGINAL DWG.	3/21/1964		
B1		(SHT 1, B/M) ADDED -29. REV FROM ORIGINAL DWG.	9/22/1965		
B2		(ALL SHEETS) REV SHT NO. BLOCKS. REV FROM ORIGINAL DWG.	9/22/1965		
B3		SEE SHT 5. REV FROM ORIGINAL DWG.	9/22/1965		
B4		SEE SHT 6. REV FROM ORIGINAL DWG.	9/22/1965		
C		SEE SHT 3. REV FROM ORIGINAL DWG.	10/26/1965		
D		(1) WAS x 488. REV FROM ORIGINAL DWG.	7/8/1970		
E		FINISH CH'D FROM CAD PLATE TO BLACK OXIDE. DIM CHANGES -.560 TO .812 & .594 TO .340 PER D.W.	11/10/2003	RJC	DW
F		MADE INDIVIDUAL TOOL DWGS. & MADE THIS THE KIT DWG. PER E.B.	7/15/2011	RJC	RW
G		ADDED -29 FOAM WAS EGGSHELL IS B/O FROM I.R. SPECIALTIES.	11/13/2013	CFS	
11	15-0312	UPDATED TO NEW DRAFTING STANDARDS. -29 SHEET 2 CH'D DIMS WAS .31 IS 2X .31. WAS 7° IS (2X 7°). WAS 2X 20° IS (2X 20°). WAS R.63 IS 4X R.63. -29 SHEET 3 CH'D DIM WAS 26X R.50 20X 1.00 IS 12X R.50. ADDED DIMS 10X R.50 1.00, 4X R.50 1.63.	10/1/2015	DPD	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 18840845

19-01-09

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TACH. GEN. PULLER ASSY.		RB6796941-200	1
				1	STARTER PULLER ASSY.		RB6796941-201	1
				1	PTO PULLER ASSY.		RB6796941-202	1
				1	SLIDE HAMMER ASSY.		RB6796941-203	1
				1	ADAPTER		RB6796941-12	1
				1	GUIDE		RB6796941-13	1
				1	GUIDE		RB6796941-14	1
				1	GUIDE		RB6796941-15	1
				1	PUNCH		RB6796941-16	1
				1	PUNCH		RB6796941-17	1
				1	PUNCH		RB6796941-18	1
				1	PUNCH		RB6796941-19	1
				1	PUNCH		RB6796941-20	1
		B/O	-27	1	PISTOL CASE		RSR GROUP #10164 (WHEN PURCHASED AS KIT)	1
		B/O	-29	1	BOTTOM FOAM	Y-20 BLACK	3-3/8 X 13-1/8 X 16-1/2 (I.R. SPECIALTIES)	2&3

DART AEROSPACE	
TITLE REPLACEMENT KIT - OIL SEALS	
DWG NO.	REV
RB6796941	11
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC
SCALE 1:8	USED ON MODEL
DATE 8/3/2010	ALLISON T63-A-5
SHEET 1 OF 3	